

Date: Monday, 07/04/2008 11:47:21 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: PLATE
Job Number	: 38434		
Estimate Number	: 13143		
P.O. Number	:	Part Number	: D37311
This Issue	: 07/04/2008 S.O. No. :	Drawing Number	: D3731 REVB
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: B
Previous Run	: 38073	Material	:
Written By	:	Due Date	: 18/04/2008 Qty: 12 Um: Each
Checked & Approved By	: <u>JD 08.4.06</u>		
Comment	: Est Rev:A 08-01-30 new issue DD verified by:EC Est Rev:B 08-03-18 chg to revB DD verified by:		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S125	6061-T6 .125 Sheet
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Comment: Qty.: 0.0504 sf(s)/Unit Total : 0.6048 sf(s)
 6061T6 aluminium sheet .125" thick
 (M6061T6S125)
 Batch: 106634 B 8-4-8

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3731
 Dwg Rev: B B 8-4-8
 Prog Rev: B
 2- Deburr if necessary

(19)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

5 08/04/08 (19) cont

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Deburr if necessary

EB 08/04/08 (19)

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Part Number: D37311

Job Number:



Seq. #: Machine Or Operation: Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/04/08 (15) counts

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FL 08/04/08 (15)

8.0

POWDER COATING

POWDER COATING



M 107550



(15X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M-L 08/04/09

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 08/04/09 (15)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart part # using a fine point permanent marker and Stock

Location: *117*

8/4/9

SP (15X)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



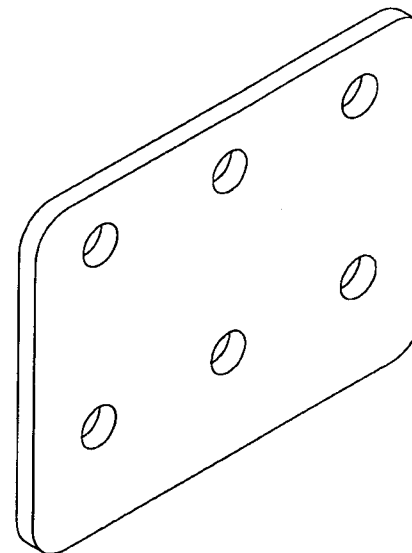
Comment: FINAL INSPECTION/W/O RELEASE

08/04/10

Job Completion



u 08.04.10









D3731-1 PLATE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 38434

RELEASED
08.03.17 MP

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.125 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF DART SPEC M6061T6S.125)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY D3731-1 WITH DART P/N D3731-1 USING FINE POINT PERMANENT INK MARKER 
- 7) WEIGHT: 0.08 lbs

B	DELETE -3. SHEET 2 ZONE B4 Ø0.265 HOLE WAS Ø0.201	AJS	08.03.06
A	INITIAL RELEASE	AJS	08.01.28
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3731	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		PLATE	NTS
DATE	08.03.06	COPYRIGHT © 2008 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8

7

6

5

4

3

2

1

D

D

C

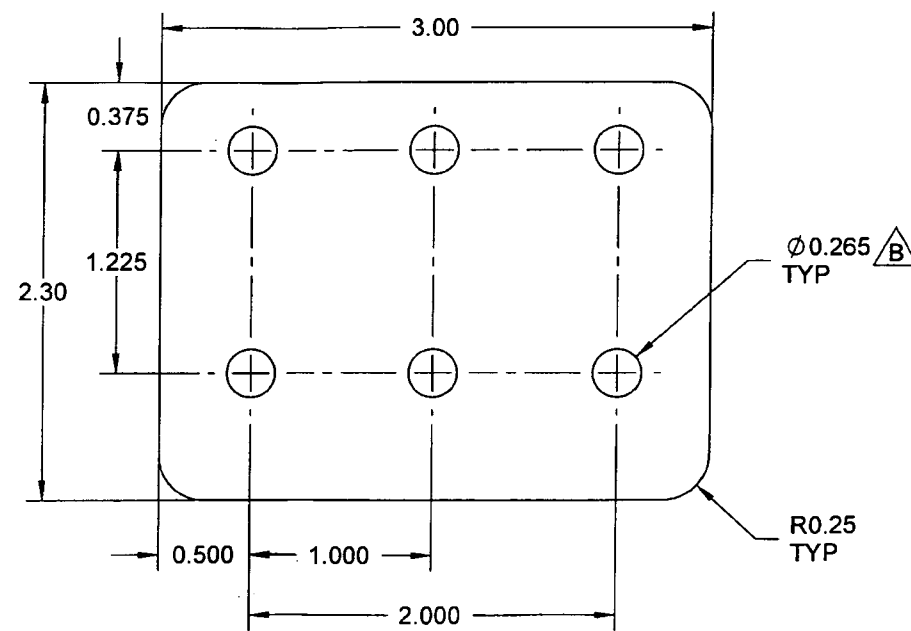
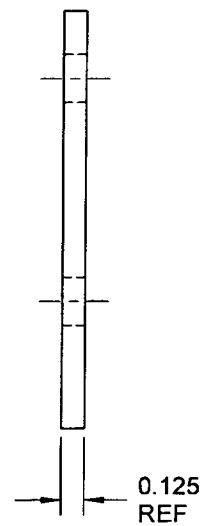
C

B

B

A

A



D3731-1 PLATE

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WITHOUT NOTICE
WORK ORDER
NO. 38434

08.03.17.17D

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ME	DRAWING NO.	REV. B
MFG. APPR.	ME	D3731	SHEET 2 OF 2
APPROVED	ME	TITLE	SCALE
DE APPR.	ME	PLATE	NTS
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